

Work Order ID 74257

Tuesday, September 27, 2011 1:53:23 PM



Ship Oct

Page 1

Item ID: D3915-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Lid Assembly, Long Basket

Start Date: 9/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *AME*

Date: *11-09-27* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3915

C

100

Weld per dwg A/R Aluminum rod Batch: 0.00



Large Fab

117889

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

AMS 11/10/03

SY 11/10/03 (1x)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

1 0 2E11/10/03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 74257

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| Item ID: | D3915-041 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Light Lid Assembly, Long Basket | | | | | |
| Start Date: | 9/27/2011 | Start Qty: | 1.00 | Cust Item ID: | | |
| Required Date: | 10/7/2011 | Req'd Qty: | 1.00 | Customer: | | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------------|---------------------------------------------------------------------------------------------------------|----------------------|---------|------------|--------------|---------------|---------------|------------------|----------------|
| 120 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | 5 11/10/04 | | | | | |
| 130 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE*** | 0.00 0.00 | | | | | | | |
| 140 Large Fab Large Fab | Weld per dwg A/R Aluminum rod Batch: Memo 1- weld (4) corners | 0.00 0.00 | | 4 117889 | | | | | |

IX PM-11/10/04

11/10/04 (1x)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/10/04

155

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8 mic/05

0

inspect fit of lid with base

157

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1- realodine corners
do not acid etch

1 BR 11-10-5.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|--------------------------------------------|-----------------|--|---------------|-------|--|
| Item ID: D3915-041 | Accept | | Setup | Start | |
| Revision ID: | | | | Stop | |
| Item Name: Light Lid Assembly, Long Basket | | | | | |
| Start Date: 9/27/2011 | Start Qty: 1.00 | | Cust Item ID: | | |
| Required Date: 10/7/2011 | Req'd Qty: 1.00 | | Customer: | | |
| Reference: | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----|----------------------------------------------|------|--|--|--|--|--|--|--|
| 160 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
|-----|----------------------------------------------|------|--|--|--|--|--|--|--|



Powdercoat

Powder Coating

Memo

- 1- touch up corner with alodine only
- 2- Plug holes prior to

1ST COAT:

START TIME: 1:50

OVEN TEMPERATURE: 320

FINISH TIME: 2:20

***** 2nd coat if necessary *****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1X M-L 11/10/05

| | | | | | | | | | |
|-----|--------------------------|------|--|--|--|--|--|--|--|
| 170 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
|-----|--------------------------|------|--|--|--|--|--|--|--|



QC

Quality Control

Memo

1 / 11/10/05

| W/O: | | WORK ORDER CHANGES | | | | | |
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Start Date: 9/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

180

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Install webbing as per dwg

2- Install placard and label as per dwg

ES 11/10/06 (1)

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 mso/lu

(10)

200

Identify as per dwg & Stock Location *GA*

0.00



Packaging

Memo

0.00

Packaging

w/o
~~7-11~~

74254

ES 11/10/06 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Setup Start



Revision ID:

Stop



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Start Date: 9/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/12

mf 11-10-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Tuesday, September 27, 2011 1:53:20 PM

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes with the objectives and goals to determine the effectiveness of the project and identify areas for improvement.

[illegible]

Required Date: 10/7/2011

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

[illegible]

2

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and understanding the causes and effects.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals and objectives.

4. The fourth step is to implement the plan. This involves putting the plan into action and making any necessary adjustments.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals and objectives have been met.

6. The sixth step is to reflect on the process. This involves thinking about what worked well and what could be improved for next time.

7. The seventh step is to share the results. This involves telling others about what you have learned and how you solved the problem.

8. The eighth step is to continue to learn. This involves staying up-to-date on new information and techniques and being open to feedback.

9. The ninth step is to be proactive. This involves looking for problems before they happen and taking steps to prevent them.

10. The tenth step is to be resilient. This involves staying positive and determined even when things get tough.

2

3

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and identifying any areas for improvement or further action.

3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 1:53:20 PM

Page 2

Work Order ID: 74257

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 9/27/2011

Required Date: 10/7/2011

Start Qty: 1.00

Required Qty: 1.00

D4019-3

 Rib

Manufactured No

100 Each

8.0000 3 3



PMB 11/10/03

Location

Loc Qty

Loc Code

WA

8

63667

0

68605

8

3

D4035-045

 Lid Rib Assembly, Fwd (Light)

Manufactured No

100 Each

2.0000 1 1



PMB 11/10/03

Location

Loc Qty

Loc Code

WA006

2

68545

2

1

D4035-047

 Lid Rib Assembly, Aft (Light)

Manufactured No

100 Each

3.0000 1 1



PMB 11/10/03

Location

Loc Qty

Loc Code

WA

3

63669

0

68546

1

71225

2

1

D4056-1

 Label Plate

Manufactured No

100 Each

4.0000 1 1



PMB 11/10/03

Location

Loc Qty

Loc Code

WA

4

70338

4

1

D2728-1

 Dart Logo label

Manufactured No

180 Each

0.0000 1 1



115050

[Signature]

Tuesday, September 27, 2011 1:53:20 PM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Page 3

Work Order ID: 74257

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 9/27/2011

Required Date: 10/7/2011

Start Qty: 1.00

Required Qty: 1.00

D4029-041 Manufactured No

180

Each

4.0000

1

1



Webbing (Long Basket)



SP

Location

Loc Qty

Loc Code

st503

4

69499

4

MS20600-AD4W3

Purchased

No

180

Each

1,459.000

34

34



PK

SP

Cherry Rivets

Location

Loc Qty

Loc Code

GA

922

118626

922

ST321

404

111636

48

117505

321

117601

35

WA018

133

107939

133

34x

1

NAS1149DN416J

Purchased

No

180

Each

249.0000

34

34



SP 11-10-6.

Washer

Location

Loc Qty

Loc Code

ST298

249

114348

11

114597

153

13910

85

3A. 3A. 18

| W/O: | | WORK ORDER CHANGES | | | | | |
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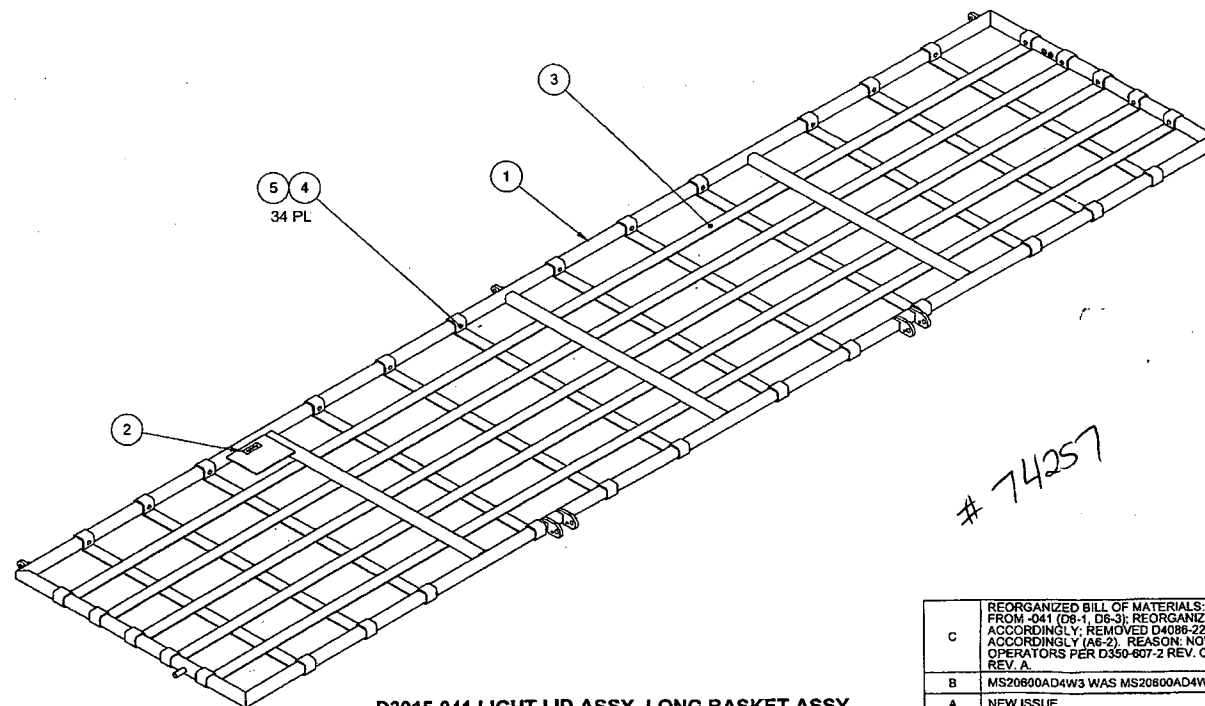
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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|----------------------------------|
| | X | D3915-041 | LIGHT LID ASSY, LONG BASKET ASSY |
| 1 | 1 | D3915-101 | BASKET LID WELDMENT ASSY |
| 2 | 1 | D2728-1 | DART LOGO LABEL |
| 3 | 1 | D4029-041 | WEBBING (LONG BASKET) |
| 4 | 34 | MS20600AD4W3 | BLIND RIVET |
| 5 | 34 | NAS1149DN416J | WASHER |



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

| | | | | | |
|------------|-------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| C | | REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D8-1, D8-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4088-220; UPDATED VIEW E ACCORDINGLY (A6-2); REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A | | MB | 10.08.05 |
| B | | MS20600AD4W3 WAS MS20600AD4WS: BOM & (B1-2) | | JPH | 10.04.06 |
| A | | NEW ISSUE | | JPH | 10.03.16 |
| REV. | DESCRIPTION | | | BY | DATE |
| DESIGN | HLS | | | DART AEROSPACE LTD | |
| DRAWN | S | | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | S | | | DRAWING NO. | REV. C |
| MFG. APPR. | S | | | D3915 | SHEET 1 OF 4 |
| APPROVED | M | | | TITLE | SCALE |
| DE APPR. | M | | | LIGHT LID ASSY-LONG BASKET | NTS |
| DATE | 10.08.05 | | | COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

RELEASED
10-08-12
ECN 10-596

74257

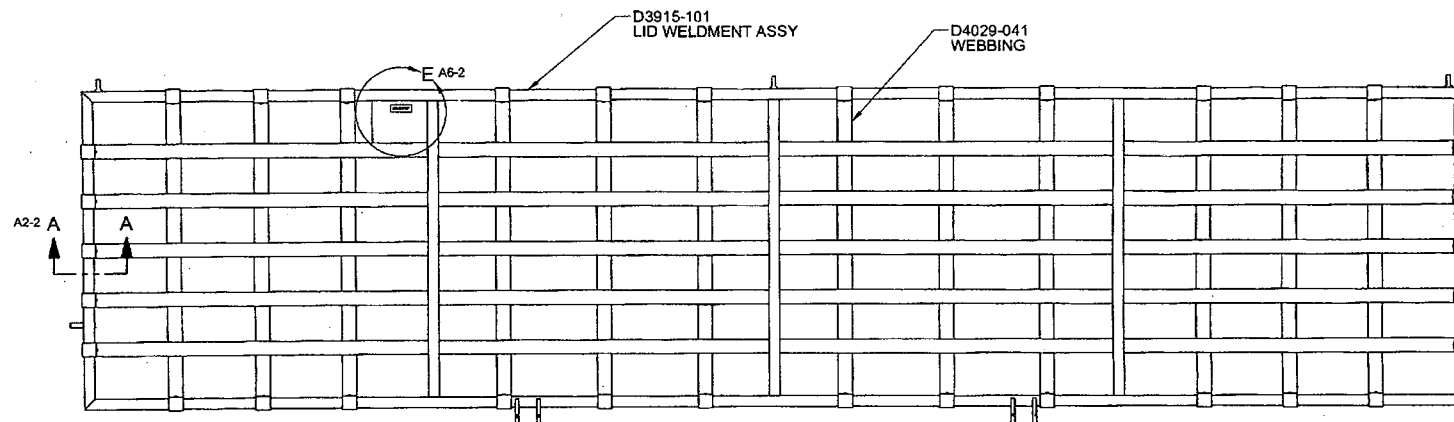
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

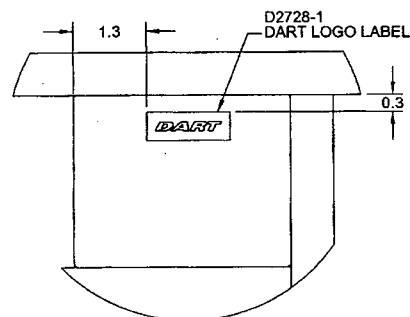
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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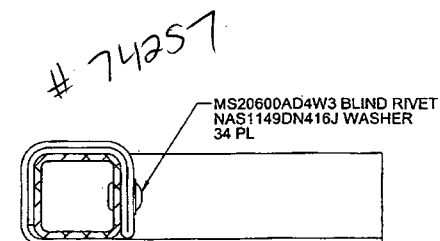
NOTE: Date & initial all entries



D3915-041 LIGHT LID ASSY, LONG BASKET



VIEW E D6-2



SECTION A-A C8-2

RELEASED
10.08.05

| | | | |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | ALS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ALS | DRAWING NO. | REV. C |
| MFG. APPR. | ALS | D3915 | SHEET 2 OF 4 |
| APPROVED | ALS | TITLE | SCALE |
| DE APPR. | ALS | LIGHT LID ASSY-LONG BASKEINTS | |
| DATE | 10.08.05 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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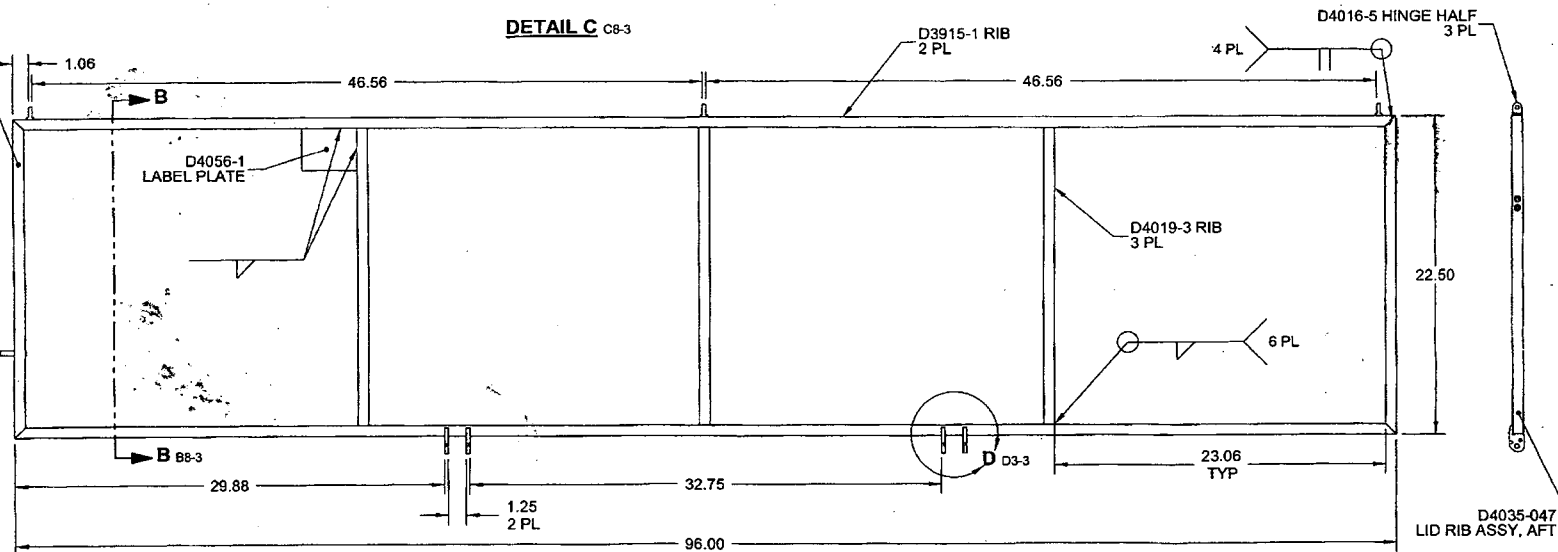
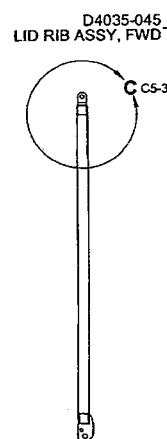
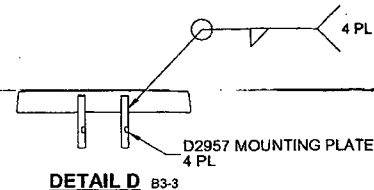
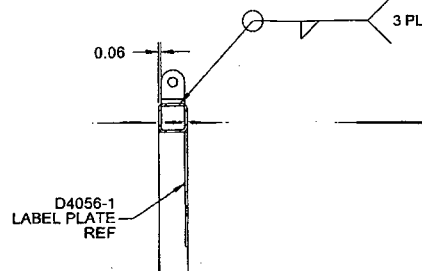
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|-----------|----------------------------------|
| | X | D3915-101 | BASKET LID WELDMENT ASSY |
| 1 | 4 | D2957 | MOUNTING PLATE |
| 2 | 2 | D3915-1 | RIB |
| 3 | 3 | D4016-5 | HINGE HALF, LIGHT LID |
| 4 | 3 | D4019-3 | RIB |
| 5 | 1 | D4035-045 | BASKET LID RIB ASSY, FWD (LIGHT) |
| 6 | 1 | D4035-047 | BASKET LID RIB ASSY, AFT (LIGHT) |
| 7 | 1 | D4056-1 | LABEL PLATE, 350 LIGHT BASKET |



D3915-101 BASKET LID WELDMENT ASSY

RELEASED
10.08.12.09

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.81 lbs
 - 8) WELD PER DART QSI 004

| | | | |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | AS | DART AEROSPACE LTD | |
| DRAWN | AS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AS | DRAWING NO. | REV. C |
| MFG. APPR. | AS | D3915 | SHEET 3 OF 4 |
| APPROVED | AS | TITLE | SCALE |
| DE APPR. | AS | LIGHT LID ASSY-LONG BASKET | NTS |
| DATE | 10.08.05 | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

#74257

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

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NOTE: Date & initial all entries